

Work Order ID 114051

114051

Page 1

Monday, March 03, 2014 1:57:23 PM

Item ID: PB67-43001-09

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 3/3/2014 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/21/2014 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MF

Date: 14-3-3

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-09	Rev C

100 Large Fab 0.00

100

Large Fab Memo 0.00

Large Fab 1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** Ensure no burn thru after welding in tube -235 and -229 only where bushing - 265 ***

6 14-03-25

DIO

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00

Quality Control

6 14-03-25

DAS 9 9-89

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00

Quality Control

6 14-03-25

DAS 9 9-89

DQA:

Date: 14/04/08



QA Closed:

Date: 14-4-4

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 11 257	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. P1 7-43001-09		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. 11 3707		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☒	Composite ☐	Supplier ☐	

Root Cause	D	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		100	1	Operator installed wrong parts at the wrong place		Leave part has is and drill holes is	DAS 24 9-89	9 9-89	
Doc/Data				B67-43001-203 was mislabeled with B67-43001-201 was installed instead of a B67-43001-203	5 M/03/26	B67-43001-201 with weld and drill hole in B67-43001-201 and installed	14-3-25	14-03-25	
Equip/Tooling				R.C. no valve in line before weld	032042	bushing B67-43001-207 B 107856			
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bend	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Center Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Crack	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cup	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Cracking	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☒ Misread	☐ Pressure/Forced
☐ Material Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turb Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	D	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bend ☐ Not Concentric ☐ Crack ☐ Kink/Ripple/Wave ☐ Cuff ☐ Cracking ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Machine Chatter ☐ Turn Sequence ☐ Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Work Order ID 114051***114051***

Page 3

Monday, March 03, 2014 1:57:23 PM

Item ID: PB67-43001-09

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 3/3/2014 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/21/2014 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS 14-03-28

MF
14-3-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	D	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐								
Doc/Data	☐								
Equip/Tooling	☐								
Handling/Pre	☐								
Material	☐								
Operator	☐								
Offset/Setup	☐								
Process	☐								
Supplier	☐								
Training	☐								
Transport	☐								
Unapproved	☐								

FAULT CATEGORY

Landing Gear ☐ Bend ☐ Not Concentric ☐ Cra ☐ Crir Kink/Ripple/Wave ☐ Cuf ☐ Cru g ☐ Hea eat ☐ Insj ion Strip in Tube ☐ Ma 'Chatter ☐ Tur g Sequence ☐ Wa Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Picklist Print

Monday, March 03, 2014 1:57:22 PM

Page 1

Work Order ID: 114051

114051

Parent Item: PB67-43001-09

PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 3/3/2014

Required Date: 3/21/2014

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec
10.09.24 per revC dwg EC verified by:DD

IPP RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-223 *PR67-43001-223* Square Cap		Manufactured	No			100	Each	21.0000	1	6			
NA Location Mezz2 Loc Qty 21 Loc Code 47504 21													
PB67-43001-225 *PR67-43001-225* Bushing		Manufactured	No			100	Each	107.0000	4	24			
NA Location Mezz2 Loc Qty 107 Loc Code 105193 18 112762 72 99979 17													
PB67-43001-227 *PR67-43001-227* Bushing		Manufactured	No			100	Each	54.0000	2	12			
NA Location Mezz2 Loc Qty 54 Loc Code 107856 8 110599 26 112760 20													

14-03-13

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____			Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. _____			Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
			Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
			Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	D	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐								
Doc/Data	☐								
Equip/Tooling	☐								
Handling/Pre	☐								
Material	☐								
Operator	☐								
Offset/Setup	☐								
Process	☐								
Supplier	☐								
Training	☐								
Transport	☐								
Unapproved	☐								

FAULT CATEGORY

Landing Gear	General
☐ Ber g	☐ Bend
☐ Cer Not Concentric	☐ BOM/Route
☐ Cra	☐ Broken/Damage/Defect
☐ Crir Kink/Ripple/Wave	☐ Burrs
☐ Cuf	☐ Contamination
☐ Cru g	☐ Countersink
☐ Hea eat	☐ Cut Too Short
☐ Insj ion Strip in Tube	☐ Drawing
☐ Ma 'Chatter	☐ Drill Holes
☐ Tur g Sequence	☐ Finish
☐ Wa Twist in Tube	☐ Fit/Function
	☐ Folio/Program
	☐ Grain
	☐ Hardware
	☐ Inspection Incomplete/Unqualified
	☐ Instructions Incomplete/Unclear
	☐ Misaligned/off center
	☐ Mislabeled
	☐ Misread
	☐ Off-set
	☐ Out of Calibration
	☐ Out of Sequence
	☐ Outside Dimensions
	☐ Over/Under tolerance
	☐ Part Incorrect
	☐ Part Lost/Missing
	☐ Part Moved
	☐ Positioned Wrong
	☐ Power Loss/Surge
	☐ Pressure/Forced
	☐ Set-up
	☐ Temperature/Cure
	☐ Weld
	☐ Wrong Stock Pulled
	☐ Other

Picklist Print

Monday, March 03, 2014 1:57:22 PM

Page 2

Work Order ID: 114051

114051

Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 3/3/2014

Required Date: 3/21/2014

Start Qty: 6.00

Required Qty: 6.00

PB67-43001-201

Manufactured No

100 Each

18.0000

2

12

PR67-43001-201

Square Tube

**

14.03.13

Location

Loc Qty

Loc Code

Mezz2

18

107861

2

112752

16

PB67-43001-203

Manufactured No

100 Each

0.0000

1

6

PR67-43001-203

Square Tube

**

14.03.13

PB67-43001-209

Manufactured No

100 Each

16.0000

1

6

PR67-43001-209

Square Tube

**

14.03.13

Location

Loc Qty

Loc Code

Mezz2

16

111735

4

112748

12

PB67-43001-211

Manufactured No

100 Each

74.0000

6

36

PR67-43001-211

Square Tube

**

14.03.13

Location

Loc Qty

Loc Code

Mezz2

74

111125

2

111734

72

PB67-43001-213

Manufactured No

100 Each

7.0000

2

12

PR67-43001-213

Flanged Hook

**

14.03.13

Location

Loc Qty

Loc Code

Mezz2

7

99981

7

Monday, March 03, 2014 1:57:22 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	D	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐								
Doc/Data	☐								
Equip/Tooling	☐								
Handling/Pre	☐								
Material	☐								
Operator	☐								
Offset/Setup	☐								
Process	☐								
Supplier	☐								
Training	☐								
Transport	☐								
Unapproved	☐								

FAULT CATEGORY

Landing Gear ☐ Bend ☐ Center Not Concentric ☐ Cracking ☐ Kink/Ripple/Wave ☐ Cuffing ☐ Cracking ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Machine Chatter ☐ Turbomachinery Sequence ☐ Warpage/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
---	--	---	--

Picklist Print

Monday, March 03, 2014 1:57:22 PM

Page 3

Work Order ID: 114051

114051

Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 3/3/2014

Required Date: 3/21/2014

Start Qty: 6.00

Required Qty: 6.00

PB67-43001-229

Manufactured No

100

Each

1.0000

1

6

PR67-43001-229

Outer Tube

14.03.13

Location

Loc Qty

Loc Code

Mezz2

3112757

1

99978

1

6

PB67-43001-235

Manufactured No

100

Each

8.0000

1

6

PR67-43001-235

Outer Tube

14.03.13

Location

Loc Qty

Loc Code

Mezz2

112756

8

8

6

PB67-43001-239

Manufactured No

100

Each

1.0000

1

6

PR67-43001-239

Square Tube

14.03.13

Location

Loc Qty

Loc Code

Mezz2

3114053

1

99976

1

6

PB67-43001-243

Manufactured No

100

Each

9.0000

1

6

PR67-43001-243

Tube Handle Extension

14.03.13

Location

Loc Qty

Loc Code

Mezz2

112754

9

9

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	D	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐								
Doc/Data	☐								
Equip/Tooling	☐								
Handling/Pre	☐								
Material	☐								
Operator	☐								
Offset/Setup	☐								
Process	☐								
Supplier	☐								
Training	☐								
Transport	☐								
Unapproved	☐								

FAULT CATEGORY

Landing Gear ☐ Bend ☐ Not Concentric ☐ Crack ☐ Kink/Ripple/Wave ☐ Cuff ☐ Cracking ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Machine Chatter ☐ Turn Sequence ☐ Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Picklist Print

Page 4

Monday, March 03, 2014 1:57:22 PM

Work Order ID: 114051

114051

Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 3/3/2014

Required Date: 3/21/2014

Start Qty: 6.00

Required Qty: 6.00

PB67-43001-277

Manufactured No

100

Each

10.0000

1

6

PR67-43001-277

**

Contoured Male Eye

Location

Loc Qty

Loc Code

Mezz2

4

99964

4

WA003

6

110601

6

100

Each

20.0000

2

12

PB67-43001-311

Manufactured No

PR67-43001-311

**

Restraint

Location

Loc Qty

Loc Code

Mezz

1

90935

1

Mezz2

19

112691

19

100

Each

12.0000

1

6

D3440-9

Manufactured No

D3440-9

**

Tube Detent Clip Base (Supersedes B67-43001-241)

Location

Loc Qty

Loc Code

Mezz2

2

108310

2

WA003

10

111123

10

100

Each

12.0000

1

6

D3440-13

Manufactured No

D3440-13

**

Bracket (Supersedes B67-43001-273)

Location

Loc Qty

Loc Code

Mezz2

12

107855

2

111122

10

Monday, March 03, 2014 1:57:23 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

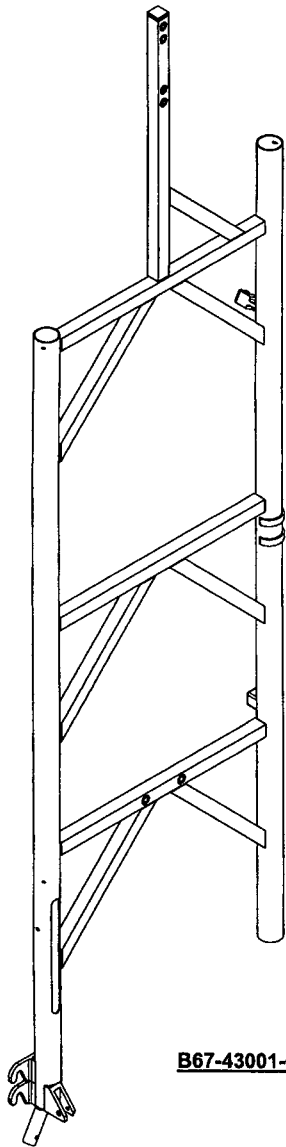
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	D	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐								
Doc/Data	☐								
Equip/Tooling	☐								
Handling/Pre	☐								
Material	☐								
Operator	☐								
Offset/Setup	☐								
Process	☐								
Supplier	☐								
Training	☐								
Transport	☐								
Unapproved	☐								

FAULT CATEGORY

Landing Gear ☐ Ber g ☐ Cer Not Concentric ☐ Cra ☐ Crir Kink/Ripple/Wave ☐ Cuf ☐ Cru ig ☐ Hei reat ☐ Ins tion Strip in Tube ☐ Ma 'Chatter ☐ Tur g Sequence ☐ Wa Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
---	--	---	--



B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

ITEM	QTY -09	P/N	DESCRIPTION
1	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
2	2	B67-43001-201	SQUARE TUBE
3	1	B67-43001-203	SQUARE TUBE
4	1	B67-43001-209	SQUARE TUBE
5	6	B67-43001-211	SQUARE TUBE
6	2	B67-43001-213	FLANGED HOOK
7	1	B67-43001-223	SQUARE CAP
8	4	B67-43001-225	BUSHING
9	2	B67-43001-227	BUSHING
10	1	B67-43001-229	OUTER TUBE
11	1	B67-43001-233	OUTER TUBE END CAP
12	1	B67-43001-235	OUTER TUBE
13	1	B67-43001-239	SQUARE TUBE
14	1	B67-43001-243	TUBE HANDLE EXTENSION
15	1	B67-43001-277	CONTOURED MALE EYE
16	2	B67-43001-311	RESTRAINT
17	1	D3440-9	TUBE DETENT CLIP BASE
18	1	D3440-13	BRACKET

#114051
mf
14-3-9

RELEASED
R 2010-09-16
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 6 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO.	REV. C
CHECKED	JP	B67-43001-09	SHEET 1 OF 3
MFG. APPR.	JP	TITLE	SCALE
APPROVED	JP	AFT BLADE FOLD ASSY WELDMENT	NTS
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.05.03		

DQA: _____

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

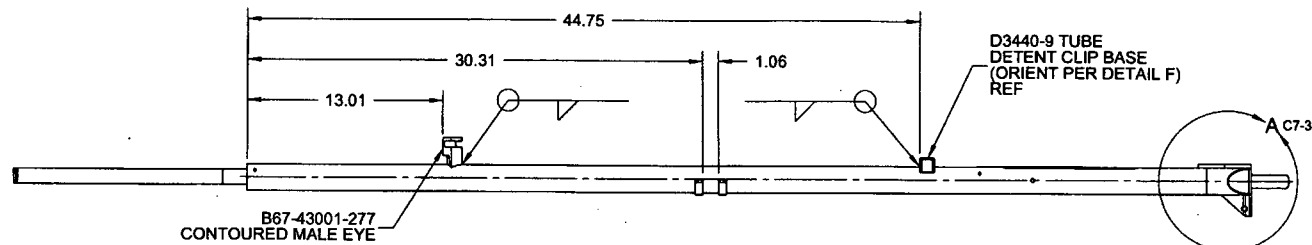
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

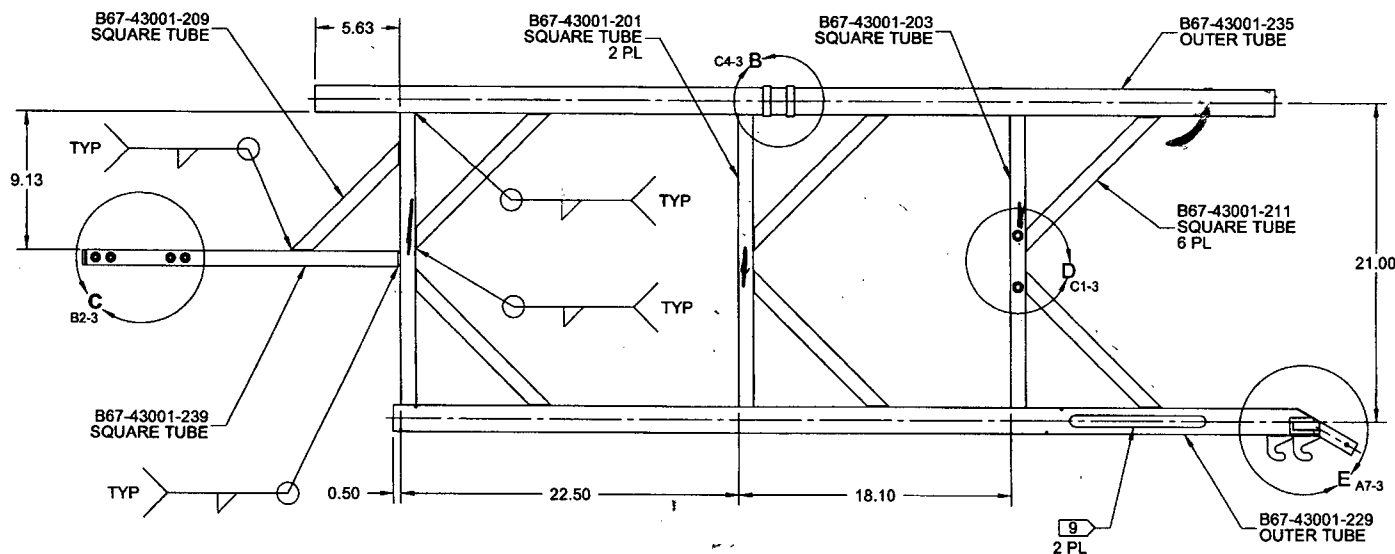
Root Cause	D	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General		
☐ Ben g	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Cen Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cra	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crir Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuf	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Cru: ig	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Hea eat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Insq ion Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Ma Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Tur 3 Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wa Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other



mf
11/05/14
14-3



B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 7.74 lbs
 - 8) WELDING: PER QSI 004
 - 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-09	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	10.05.03	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2010-09-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐								
Doc/Data ☐								
Equip/Tooling ☐								
Handling/Pre ☐								
Material ☐								
Operator ☐								
Offset/Setup ☐								
Process ☐								
Supplier ☐								
Training ☐								
Transport ☐								
Unapproved ☐								

FAULT CATEGORY

Landing Gear ☐ Bearing ☐ Center Not Concentric ☐ Cracks ☐ Critical Kink/Ripple/Wave ☐ Cuff ☐ Cracking ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Malfunction/Chatter ☐ Turbulence Sequence ☐ Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

MATE WITH TOP SURFACE OF LOWER HOOK AND ALIGN WITH CENTERLINE OF OUTER TUBE

ALIGN WITH BOTTOM EDGE OF END CAP AND CENTERLINE OF OUTER TUBE

ALIGN WITH CENTERLINE OF OUTER TUBE AND FLUSH WITH ANGLED CUT

B67-43001-243 TUBE HANDLE EXTENSION REF

ALIGN WITH CENTERLINE OF OUTER TUBE AND TO BOTTOM SURFACE OF END CAP

D3440-13 BRACKET

DETAIL A D3-2
SCALE 4X

B67-43001-229 OUTER TUBE REF

MASK INSIDE SURFACES OF BRACKET PRIOR TO POWDER COATING

B67-43001-243 TUBE HANDLE EXTENSION

B67-43001-213 FLANGED HOOK 2 PL

MASK INSIDE SURFACE OF HOOK PRIOR TO POWDER COATING

DETAIL E B3-2
SCALE 4X

MASK ALL AROUND TUBE PRIOR TO POWDER COATING

B67-43001-311 RESTRAINT 2 PL

B67-43001-201 SQUARE TUBE REF

B67-43001-235 OUTER TUBE REF

DETAIL B C5-2
SCALE 4X

B67-43001-203 SQUARE TUBE REF

B67-43001-227 BUSHING 2 PL

B67-43001-211 SQUARE TUBE REF

2 PL

DETAIL D B4-2
SCALE 4X

B67-43001-223 SQUARE CAP 2 PL

4 PL

B67-43001-225 BUSHING 4 PL

B67-43001-239 SQUARE TUBE REF

4 PL

DETAIL C B8-2
SCALE 4X

MASK INSIDE SURFACE AND HOLE (NOT SHOWN) OF CONTOURED MALE EYE PRIOR TO POWDER COATING

D3440-9 TUBE DETENT CLIP BASE MASK THREADED HOLE (NOT SHOWN) PRIOR TO POWDER COATING

DETAIL F C2-2
SCALE 4X

RELEASED
2010-09-15

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-09	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	10.05.03	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐								
Doc/Data ☐								
Equip/Tooling ☐								
Handling/Pre ☐								
Material ☐								
Operator ☐								
Offset/Setup ☐								
Process ☐								
Supplier ☐								
Training ☐								
Transport ☐								
Unapproved ☐								

FAULT CATEGORY

Landing Gear ☐ Bearing ☐ Center Not Concentric ☐ Cracks ☐ Creep/Kink/Ripple/Wave ☐ Cuff ☐ Cracking ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Material Chatter ☐ Turbulence Sequence ☐ Waist Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--